

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-018015**Date Inspected:** 31-Oct-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

<b>CWI Name:</b>	An Qing Xing		
<b>Inspected CWI report:</b>	Yes	No	N/A
<b>Electrode to specification:</b>	Yes	No	N/A
<b>Qualified Welders:</b>	Yes	No	N/A
<b>Approved Drawings:</b>	Yes	No	N/A

<b>CWI Present:</b>	Yes	No
<b>Rod Oven in Use:</b>	Yes	No
<b>Weld Procedures Followed:</b>	Yes	No
<b>Verified Joint Fit-up:</b>	Yes	No
<b>Approved WPS:</b>	Yes	No
<b>Delayed / Cancelled:</b>	Yes	No
<b>Component:</b>	OBG COMPONENT	

**Bridge No:** 34-0006**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Subhasis Bera was present during the times noted above for observations relative to the work being performed.

In process Inspection

Outside Yard

This QA Inspector observed the following work in progress:

SMAW in the 3G position for the OBG segment 11BE to 11CE, weld No.SP715-001-034.The welder is identified as #044515. ZPMC QC is identified as Mr. An Qing Xing. The welding variables recorded by QC appear to comply with WPS-B-P-2213-B-U2-FCM-1.

SMAW in the 3G position for the OBG segment 11BE to 11CE, weld No.SP354-001-055.The welder is identified as #050289. ZPMC QC is identified as Mr. An Qing Xing. The welding variables recorded by QC appear to comply with WPS-B-P-2213-B-U2-FCM-1.

SMAW in the 3G position for the OBG segment 11BE to 11CE, weld No.OBE11-010.The welder is identified as #500363. ZPMC QC is identified as Mr. An Qing Xing. The welding variables recorded by QC appear to comply with WPS-B-P-2213-B-U2-FCM-1.

FCAW in the 2F position for the OBG segment 11BE to 11CE, weld No.BP187-001-045.The welder is identified as #040367. ZPMC QC is identified as Mr. An Qing Xing. The welding variables recorded by QC appear to

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comply with WPS-B-T-2132.

Ultrasonic Testing (UT) for Service Platform at Bay#9

This QA Inspector performed Ultrasonic testing (UT) 10% of the area previously tested and accepted by ZPMC Quality control personnel. This QA inspector generated a (UT) report for this date. The members are identified as OBG service platform weld joints.

The welds designation reviewed are as follows:

SP4-B-001-001,002,003

SP7-B-001-001,002,003

SP8-B-001-001,002,003

Magnetic Particle Testing (MPT) for Service Platform at Bay#9

This Quality Assurance (QA) Inspector performed Visual inspection and verification of Magnetic Particle Testing (MT) 15% for OBG traveler rail weld. This QA inspector generated a (MT) report for this date. This area was previously tested and accepted by ZPMC QC MT technicians.

The Weld Designations are as follows

SPEP2-004-001

SPEP2-005-001

SPEP2-006-001

SPEP2-007-001

SPEP2-008-001

Visual Inspection after Blast at OBG service platform component

This Quality Assurance (QA) Inspector performed random visual inspection of OBG service platform component external surfaces after grit blasting at front of blast shop no.2. Areas that were marked by QA requiring additional grinding and repaired by ZPMC personnel.

The components are identified as SP5-6,SP5-7,SP5-8,SP6-6,SP6-7,SP6-8 and miscellaneous item .

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

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### Summary of Conversations:

No relevant conversations

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

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**Inspected By:** Bera,Subhasis

Quality Assurance Inspector

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**Reviewed By:** McClendon,Timothy

QA Reviewer